

Date: Tuesday, 12/20/2005 2:50:34 PM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : NUT PLATE ASSEMBLY
<b>Job Number</b> : 25298	
<b>Estimate Number</b> : 10812	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D3178041
<b>This Issue</b> : 12/20/2005 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D3178 REV. A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 25030	<b>Material</b> : MAKE in multi plys of 8
<b>Written By</b> : SEE COMMENT BELOW	<b>Due Date</b> : 1/30/2006 <b>Qty:</b> 8 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : SEE ABOVE USER.	
<b>Comment</b> : Est:B 03.02.28 Modify Step 1,2,3,4,21,23 KJ/RF	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S063	5052-H32 .063 Sheet
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**Comment:** Qty.: 0.0365 sf(s)/Unit Total : 0.1462 sf(s)  
 Material: 5052-H32/H34 (QQ-A-250/8) 0.063" thick  
 (M5052H32S.063) Batch: M16454

ml 06/02/20 8

2.0	SHEAR	SHEAR
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**Comment:** SHEAR  
 Cut blanks: 3.00" x 1.520"

ml 06/02/20 8

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1  
 Machine as per Folio FA296 and Dwg D3178  
 Identify as D3178-1

ml 06/02/20 8

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

ml 06/02/20 8

5.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

Ep 06/02/20 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: NUT PLATE ASSEMBLY

Job Number: 25298

Part Number: D3178041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE.1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- C'sink D3178-1 holes as per Dwg D3178

2- Deburr *SAS 06.02.20*

*SB*

*06/02/21*

*8*

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*06.02.21*

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*FF. 06.02.21*

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

*06.02.21*

10.0

MS20426AD34

RIVET



Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)

RIVET

Pick:

Qty	Part Number	Description
8	MS20426AD3-4	Rivet

Batch

*M15786*

11.0

MS21059L3

Nut Plate



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Nut Plate

Pick:

Qty	Part Number	Description
4	MS21059L3	Nut Plate

Batch

*M14602*

*SB 06/02/23*

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3178

*SB 04/02/23*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: 12 Date: 6/2/27

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: NUT PLATE ASSEMBLY

Job Number: 25298

Part Number: D3178041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC5

INSPECT WORK TO CURRENT STEP



*06-02-24*

8

Comment: INSPECT WORK TO CURRENT STEP

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *Sty 11*

*06/2/27 (8)*

15.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*SD 06/02/27*

Job Completion



*060227*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

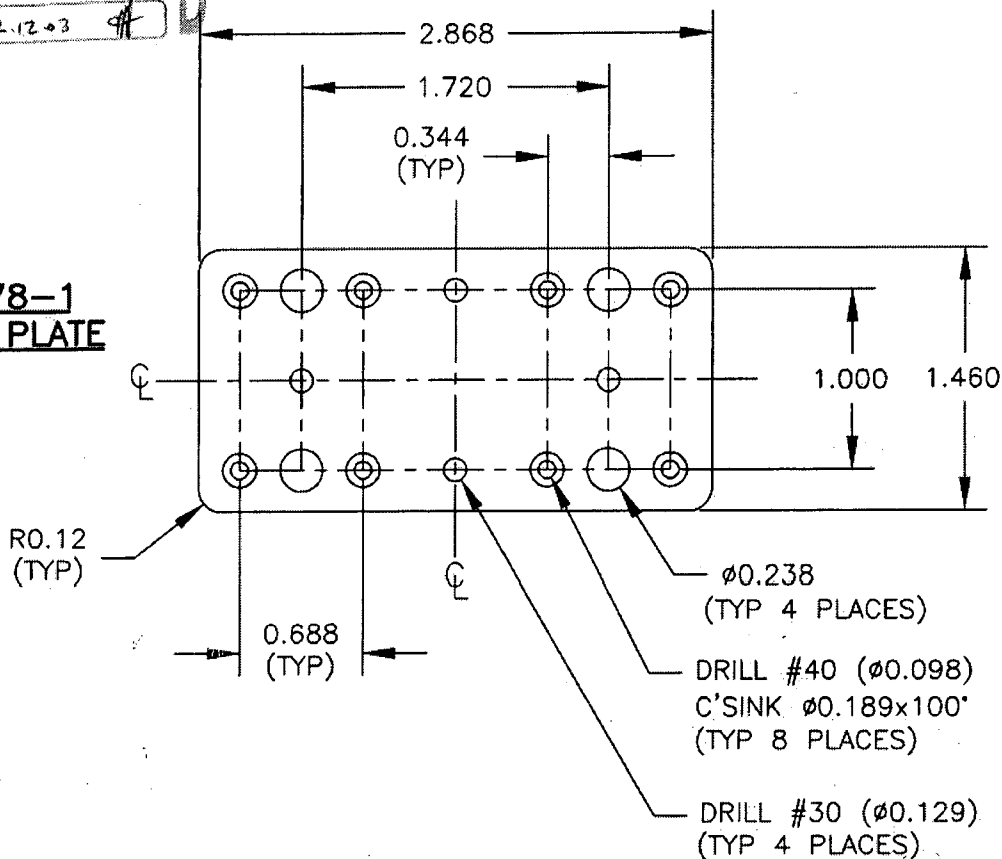




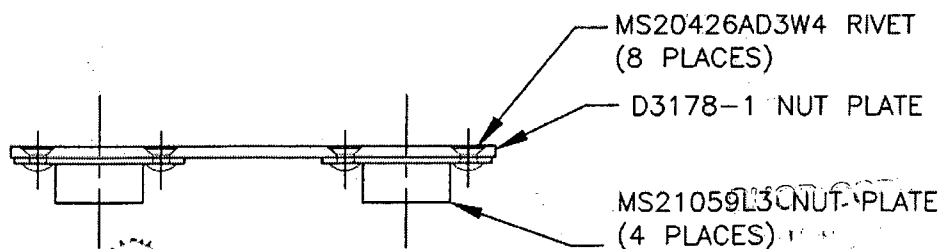
DESIGN UP	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3178	REV. A SHEET 1 OF 1
DATE 02.12.03		TITLE NUT PLATE	SCALE 1:1
A	02.12.03	NEW ISSUE	

RELEASED  
02.12.03 [Signature]

**D3178-1  
NUT PLATE**



**D3178-041  
NUT PLATE**



**NOTES. D3178-1 NUT PLATE:**

- 1) PART IS SYMMETRIC ABOUT CENTERLINES
- 2) MATERIAL: 5052-H32/H34 SHEET 0.063 THICK (QQ-A-250/8)  
(REF DART SPEC. M5052H32S.063)
- 3) BREAK ALL SHARP EDGES 0.005-0.010
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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